

Date: Tuesday, 4/18/2006 10:02:34 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ASSEMBLY
Job Number	: 26669		
Estimate Number	: 10426		
P.O. Number	: <i>N/A</i>	Part Number	: D3304044
This Issue	: 4/18/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3304 REV. B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 23756	Drawing Revision	: B
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/20/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	4 Um: Each
Comment	: Est: D 06/11.26 Revised Steps 7 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0875W065	SS TUBING
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Comment: Qty.: 1.9469 f(s)/Unit Total : 7.7876 f(s)

Material: AISI 304/316 SS tubing 0.875" x 0.065" wall
 (M304TR0.875W.065)

Batch: *M16258**06/06/14*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

- 1- Cut blank: 22.00" as per Dwg D3304
- 2- Turn as per Folio FA458 and Dwg D3304
- 3- Deburr

*N/A Machined Manually**06/06/14 4*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/06/14 4

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.G**06/06/14**4*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Drill as per Dwg D3304 using drill Jig D3304-T1
- 2- Form as per Dwg D3304
- 3- Cut tube to length as per Dwg D3304
- 4- Deburr

[Signature]
FF 06-10-26
06-10-11

(PTO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3304-044 PAR #: N/A Fault Category: Prod / FAB. Ass' med & Small NCR: Yes No DQA: PD Date: 06/18/27
 QA: N/C Closed: KG Date: 06/10/27

NCR: <u>26669</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/11	5.0	1 Tube WAS cut 1" short of the total length. Employee cut off the bend line by mistake on the top section.	<u>FF</u> 06/10/11	Scrap: destroy	<u>FF</u> 06/10/11	<u>06/10/25</u>	<u>06/10/25</u>	<u>06/10/25</u>
06/10/26	5	1 piece was ^{blend} was out of tolerance	<u>FF</u> 06/10/26	Scrap: destroy	<u>FF</u> 06/10/26	<u>06/10/26</u>	<u>06/10/26</u>	<u>06/10/26</u>

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:02:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 26669

Part Number: D3304044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/10/26 (2)

7.0

D33048

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket

Pick:

Qty	Part Number	Description	Batch
1	D3304-8	Bracket	B25157

PD 06-10-26 (2)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bracket as per Dwg D3304 and QSI 004

PD 06-10-26 (2)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06/10/26 (2)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL 06 10 27 (2)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FF 06-10-27 (2)

12.0

BLBS0016

PIP PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PIP PIN

Pick:

Qty	Part Number	Description	Batch
1	BLBS-0016	Pip Pin	M100726

FF 06-10-27 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:02:34 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 26669

Part Number: D3304044

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Loop Sleeve

Pick:

Qty Part Number Description Batch

2 CBL-460 Loop Sleeve

M100644

FF 06-10-27

2

14.0

CBL1240

Cable



Comment: Qty.: 1.0416 f(s)/Unit Total : 4.1664 f(s)

Cable

Pick:

Qty Part Number Description Batch

12.5" CBL-1240 Cable

M102439

FF 06-10-27

2

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard and pip pin as per Dwg D3304

Identify as D3304-044

FF 06-10-27

2

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/27

2

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

10 6/10/27

(2)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/10/27

(2)

Job Completion



u 06-10-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

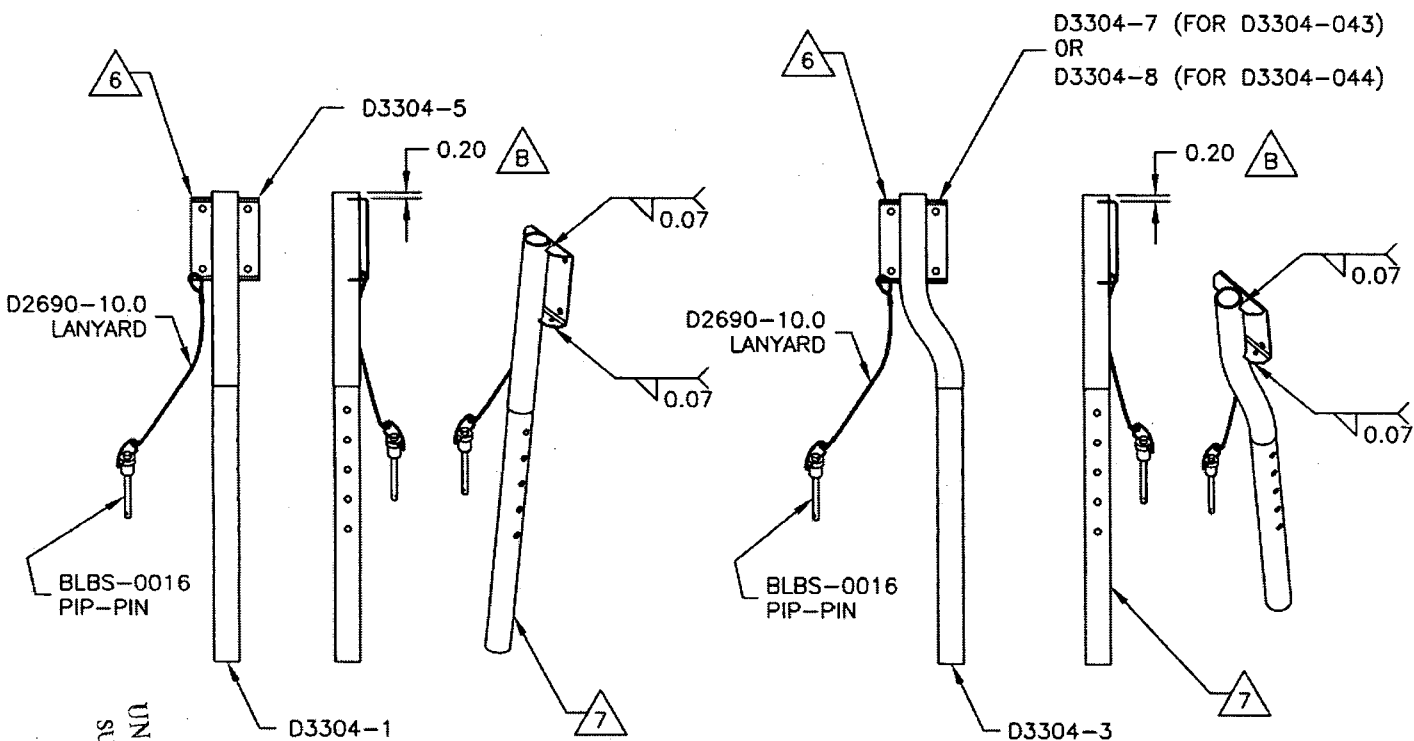
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.07.15	TITLE	D3304	REV. B
			TUBE ASSEMBLY	SHEET 1 OF 4
				SCALE
				1:6
A	04.08.18	NEW ISSUE		
B	05.07.15	UPDATE DIMENSIONS: ADD D3304-7/-8		



**D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE**

D3304-041 TUBE ASSEMBLY

D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N 0412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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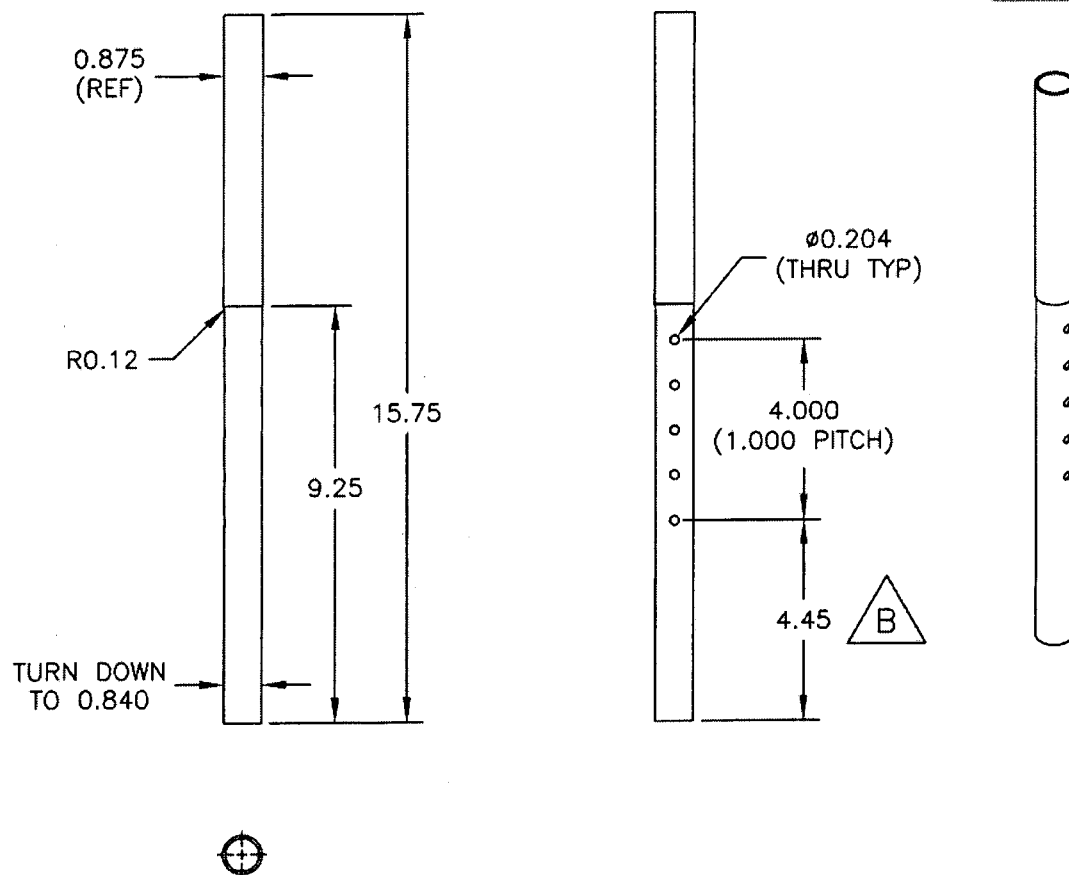
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WORK ORDER

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05.08.11



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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

RELEASED
05-08-11 *[Signature]*



D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

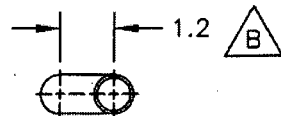
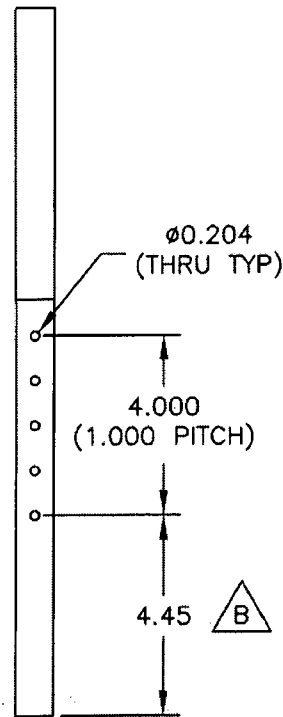
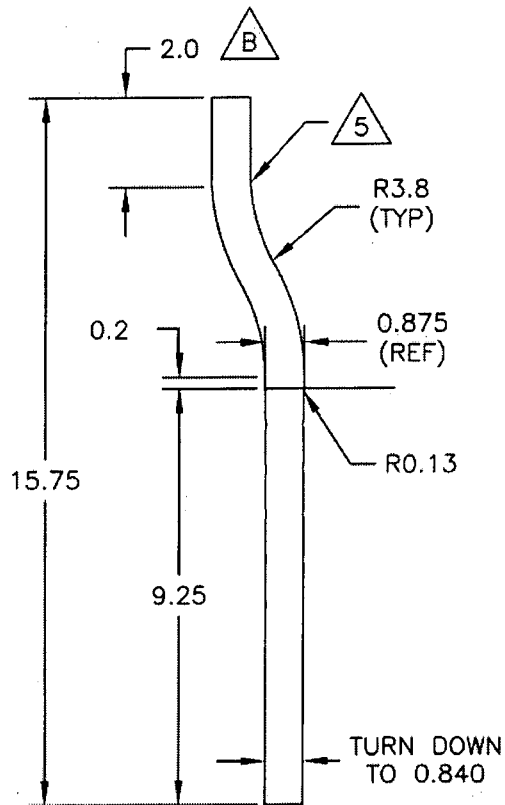
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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

**D3304-3 TUBE****D3304-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

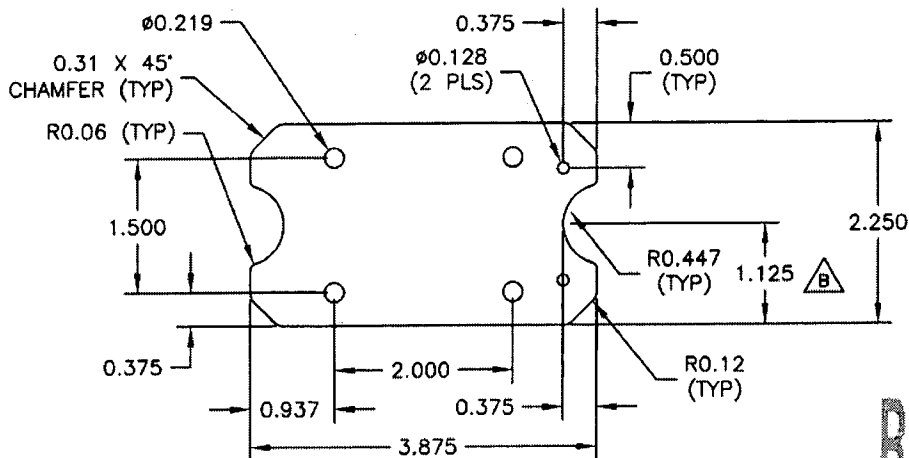
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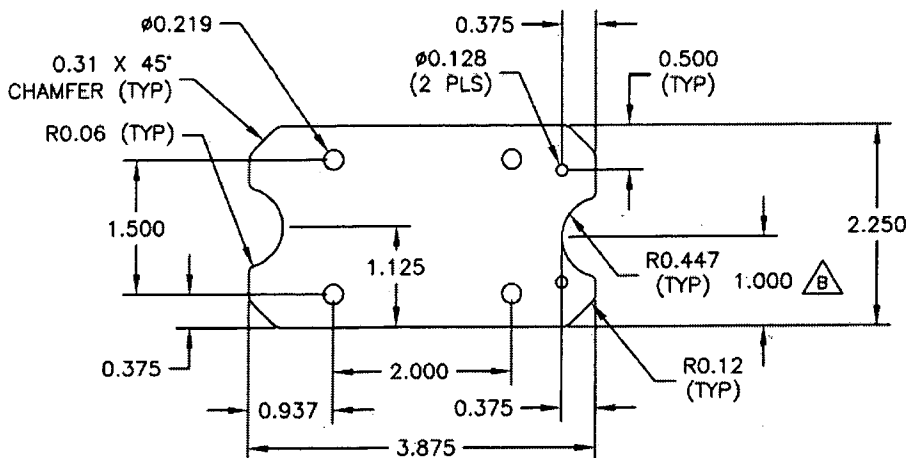


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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:2

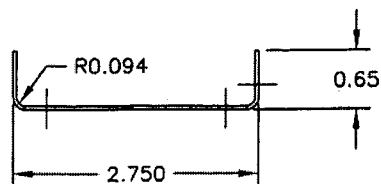


D3304-5 FLAT PATTERN

RELEASED
05.08.11



D3304-7/-8 FLAT PATTERN



**D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

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WORK ORDER

NO. 26669

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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